







Date: Monday, 9/11/2006 3:43:13 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BUSHING
Job Number : 28478	
Estimate Number : 12411	
P.O. Number : N/A	Part Number : D35011
This Issue : 9/11/2006 S.O. No. : N/A	Drawing Number : D3501 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 28127	Material : N/A
Written By : <u> </u>	Due Date : 9/30/2006
Checked & Approved By : <u> </u>	Qty: <u>220</u> Um: Each
Comment : Est Rev:A New Issue 06-05-09 JLM	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	M303R0750 303 Round Bar .75"
	
Comment: Qty.: 0.0831 f(s)/Unit Total : 16.6110 f(s) 303 Round Bar .75" <u>18.3</u> (M303R0750) Batch: <u>M102318</u> <u>06/10/12</u>	
2.0	HARDINGE HARDINGE CNC LATHE SMALL
	
Comment: 1-TURN AS PER FOLIO FA650 & DWG D3501 , FOLIO REV: <u>A</u> DWG REV: <u>A</u> 2-DEBURR AS REQUIRED <u>06/10/12</u> <u>220</u>	
3.0	QC2 INSPECT PARTS AS THEY COME OFF MACHINE
	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>06/10/12</u> <u>220</u>	
4.0	QC8 SECOND CHECK
	
Comment: SECOND CHECK <u>06.10.13</u> <u>220</u>	
5.0	PACKAGING 1 PACKAGING RESOURCE #1
	
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>ST 446</u> <u>06/10/13</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: DE Date: 06/10/16

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 9/11/2006 3:43:13 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 28478

Part Number: D35011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



228

Comment: FINAL INSPECTION/W/O RELEASE

06/10/16

Job Completion



U 06/10-13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

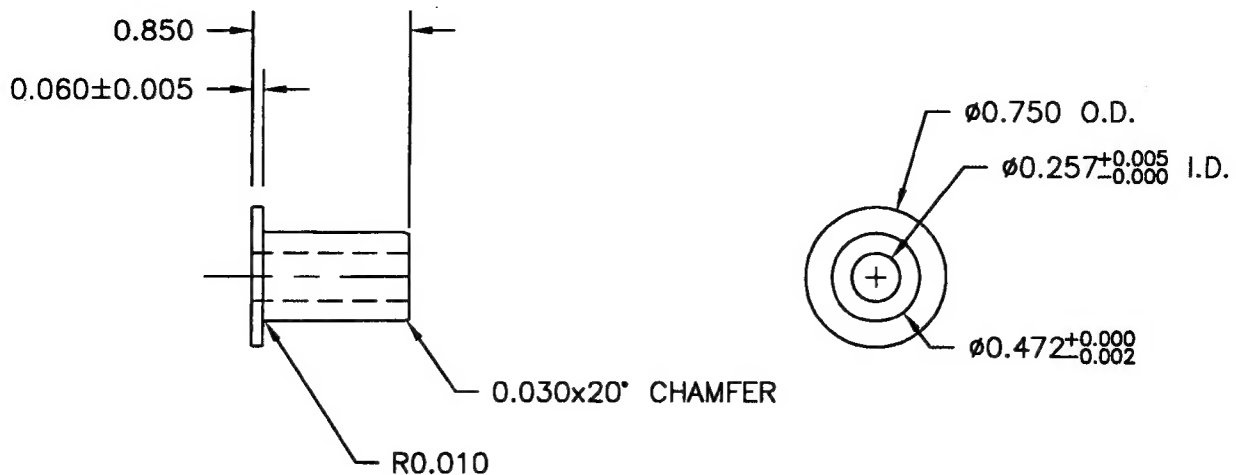
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN QP	DRAWN BY QP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3501	REV. A SHEET 1 OF 1
DATE 06.04.18		TITLE BUSHING	SCALE 1:1
A	06.04.18	NEW ISSUE	

**D3501-1 BUSHING**

- 1) MATERIAL: AISI 303 SS (REF DART SPEC. M303R)
- 2) FINISH: NONE
- 3) BREAK ALL UNMACHINED SHARP CORNERS 0.010 MAX
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
RELEASED
16.08.18
SUBJECT TO AMENDMENT
WITHOUT NOTICE
EP
NO 28478

Copyright © 2006 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART AEROSPACE LTD		Work Order: 28478
Description: Crosstube Assembly Bushing		Part Number: D3501-1
Inspection Dwg: D3501	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	.750	±.010	.750	✓			
	.472	+ .000 - .002	.472	✓			
	.257	+ .005 - .000	.260	✓			
	.850	±.010	.849	✓			
	.060	± .005	.059	✓			
	.030 x 20°	±.010	.030 x 20°	✓			
SIDE B							

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 06/10/12	Date: 06/10/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	